

Date: Monday, 2/11/2008 2:11:56 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |          |                  |                         |  |          |
|-----------------------|---------------------------------------|----------|------------------|-------------------------|--|----------|
| Customer              | : CU-DAR001 Dart Helicopters Services |          | Drawing Name     | : 204 SKIDTUBE "I" BEAM |  |          |
| Job Number            | : 37328                               |          | Part Number      | : D2597                 |  |          |
| Estimate Number       | : 10996                               |          | Drawing Number   | : D2597 REV D           |  |          |
| P.O. Number           | :                                     |          | Project Number   | : N/A                   |  |          |
| This Issue            | 2/11/2008                             | S.O. No. | Drawing Revision | : D                     |  |          |
| Prsht Rev.            | : NC                                  |          | Material         | :                       |  |          |
| First Issue           | 11                                    | Type     | Due Date         | Qty:                    | 4                                      | Um: Each |
| Previous Run          | : 29961                               |          | Comment          | Est: D 98.02.15         | Eliminated DEO, Changed Dwg RevisionKS |          |
| Written By            | :                                     |          | Signature        |                         |  |          |
| Checked & Approved By | :                                     |          | Signature        |                         |  |          |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :   |
|---|-----------------------|---|
| 1.0   | D25003100             | Ext'n 'I' Beam Web 4"   |
|   |                       |    |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)<br>Extrusion "I" Beam Web 4"<br>Pick;<br>Qty Part Number Description Batch<br>1 D2500-3-100 Extrusion B33940 ④ M 8-2-15 |                       |   |
| 2.0   | LANDING GEAR 1        | LANDING GEAR RESOURCE 1   |
|   |                       |  |
| Comment: LANDING GEAR RESOURCE 1<br>Cut D2500-3 to length: 84.25"<br>Use Jig DT8094 to drill pilot holes.<br>Open to 0.625 diameter using a uni-bit.                              |                       |   |
| 3.0   | QC5                   | INSPECT WORK TO CURRENT STEP  |
|   |                       |    |
| Comment: INSPECT WORK TO CURRENT STEP   |                       |   |
| 4.0   | HAND FINISHING1       | HAND FINISHING RESOURCE #1  |
|   |                       |  |
| Comment: HAND FINISHING RESOURCE #1<br>Acid Etch and Alodine per QSI 005.4.1  |                       |   |
| 5.0   | QC3                   | INSPECT POWDER COAT/CHEMICAL CONVERSION   |
|   |                       |  |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  |                       |   |

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/2022  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:11:57 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 SKIDTUBE "I" BEAM

Job Number: 37328

Part Number: D2597

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3G

*6-08-02-20*

(4)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*1-08-02-20*

Job Completion



*2008-2-10*

(4)

*W*

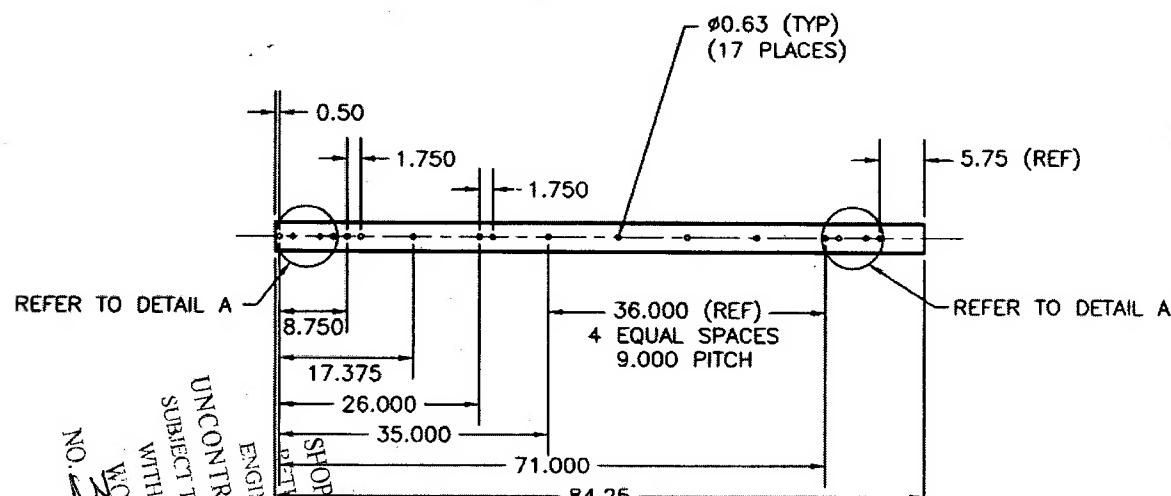
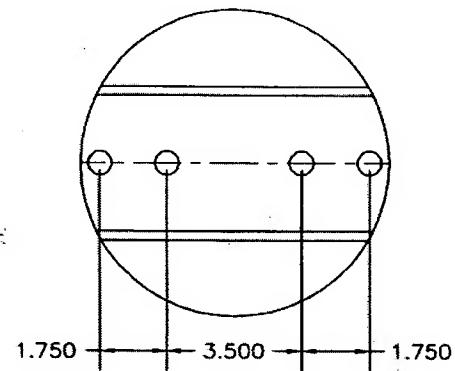
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

DETAIL A  
SCALE 5:24



WORK ORDER NO. 31328  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
PETER  
TO  
SHOP COPY

MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**



**RELEASED**  
18.9.17  
DS

| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
|-------------------------------|--------------------------------|---|--------------|
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.                                       | REV. D       |
| DATE                          |                                | TITLE   | SHEET 1 OF 1 |
| 98.09.14                      |                                | D2597   | 1.24         |
| A                             | 96.09.16                       | NEW ISSUE   |              |
| B                             | 96.10.29                       | 5.75 WAS 0.50                                     |              |
| C                             | 97.07.23                       | 0.63 WAS 0.56                                     |              |
| D                             | 98.09.14                       | INCORPORATED DEO 9097                             |              |